

Date: Tuesday, 23/09/2008 10:22:16 AM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|-----------------------|--|--|------------------|--------------------------------|--|--|
| Customer Number | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : PLATE | | |
| Estimate Number | : 42226 | | Part Number | : D323811 | | |
| P.O. Number | : 12562 | | Drawing Number | : D3238 REV.C | | |
| This Issue | : 23/09/2008 S.O. No. : | | Project Number | : N/A | | |
| Prsht Rev. | : NC | | Drawing Revision | : C | | |
| First Issue | : / / | | Material | : | | |
| Previous Run | : 33512 | | Due Date | : 20/10/2008 Qty: 132 Um: Each | | |
| Written By | : | | | | | |
| Checked & Approved By | : <u>JUL 08.9.23</u> | | | | | |
| Comment | : Est Rev:A New Issue 06-10-20 EC | | | | | |
| | Est Rev:B Now on Waterjet 07-01-26 JLM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--|
| 1.0 | M5052H32S020 | 5052-H32 .020 Sheet |
| Comment: Qty.: 0 sf(s)/Unit Total : 2 sf(s) 5052H32 aluminum sheet 0.020" thick batch: <u>4894</u> <u>IB 8-10-7</u> | | |
| 2.0 | WATER JET | FLOW WATER JET |
| Comment: FLOW WATER JET 1-Cut as per Dwg D3238 Dwg Rev: <u>E</u> <u>IB 8-10-7</u> Prog Rev: <u>E</u> | | |
| Comment: 2-Deburr if necessary <u>IB 08/10/07</u> <u>444</u> <u>141</u> <u>138</u> | | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
| Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>IB 8-10-7</u> | | |
| 4.0 | QC8 | SECOND CHECK |
| Comment: SECOND CHECK <u>8/08/08/07</u> <u>8/14/07</u> <u>counts</u> | | |
| 5.0 | HAND FINISHING1 | HAND FINISHING RESOURCE #1 |
| Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1 <u>M</u> <u>08-10-08</u> <u>X 141</u> | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 23/09/2008 10:22:16 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PLATE

Job Number: 42226

Part Number: D323811

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(14X)

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m-h 08/10/08

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

Resh/08 (14)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08 ff

Job Completion



W 08.10.09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|-----------------------|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 42224 |
| Description: Plate | Part Number: | D3238-11 |
| Inspection Dwg: D3238 | Rev: C | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

| | | |
|------------------------|----------------------|-------------------------|
| Measured by: <u>BB</u> | Audited by: <u>S</u> | Prototype Approval: N/A |
| Date: 8/10/07 | Date: 05/05/07 | Date: N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|------------------|------------|----------|
| A | 07.01.17 | New Issue | KJ/JLM | |
| B | 07.02.23 | Dwg Rev. updated | KJ/JLM | |

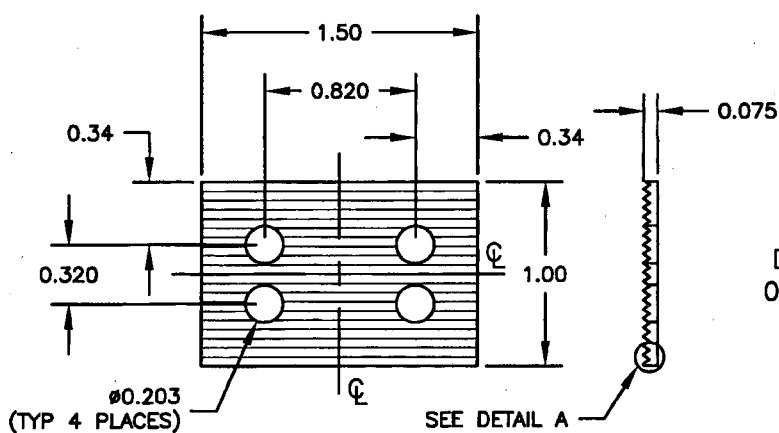
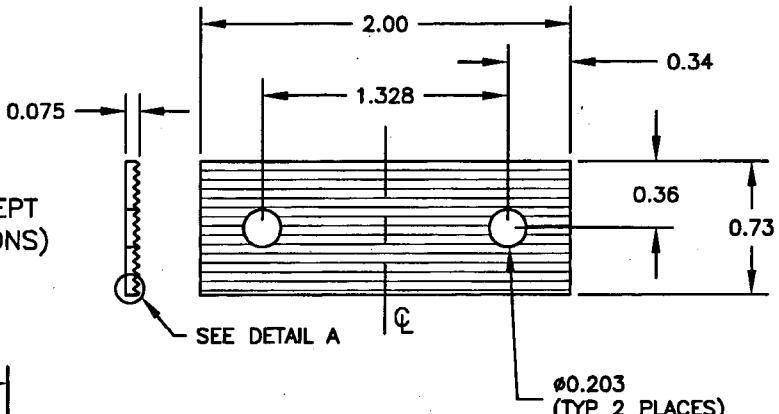
DART

| | | | |
|----------------------|-----------------------|---|------------------------|
| DESIGN <i>CH</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>CE</i> | APPROVED <i>CH</i> | DRAWING NO. D3238 | REV. C SHEET 1 OF 3 |
| DATE 07.02.19 | | TITLE PLATE | SCALE 1:1 |
| A | 03.11.25 | NEW ISSUE | |
| B | 07.01.17 | ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6 | |
| C | 07.02.19 | ADD 5052-H32 OPTION | |

RELEASED

07.02.20 *CH*

D3238-1 PLATE (SHOWN)
D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
- 11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT $\frac{1}{4}$

SHOP COPY

RETURN TO

ENGINEERING

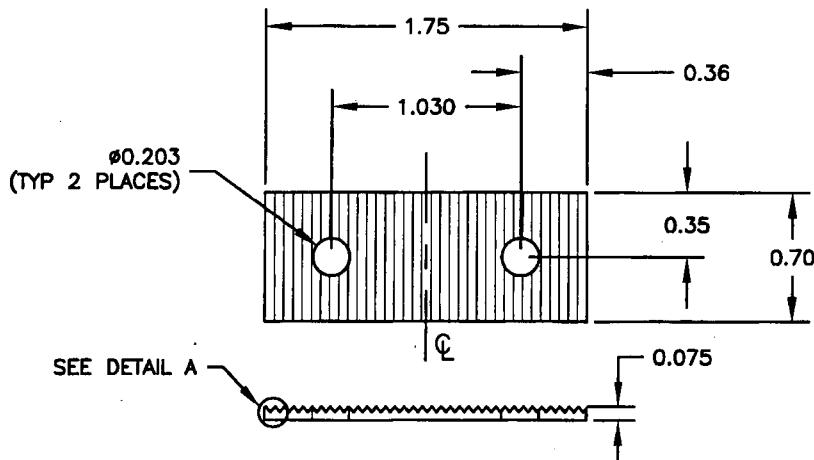
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

DART

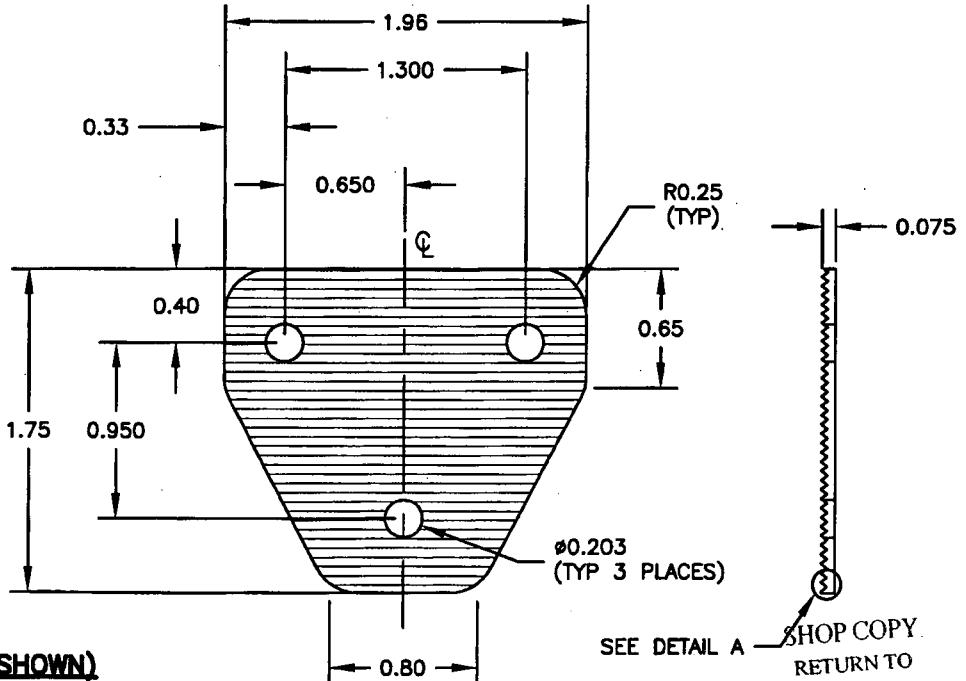
| | | | | |
|----------------------|-----------------------|---|--------------|--------------|
| DESIGN <i>#</i> | DRAWN BY <i>CB</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | | |
| CHECKED <i>CE</i> | APPROVED <i>HH</i> | DRAWING NO. D3238 | REV. C | SHEET 2 OF 3 |
| DATE 07.02.19 | TITLE PLATE | | SCALE 1:1 | |



RELEASED

07.02.20

D3238-5 PLATE (SHOWN)



D32.38-21 PLATE (SHOWN).

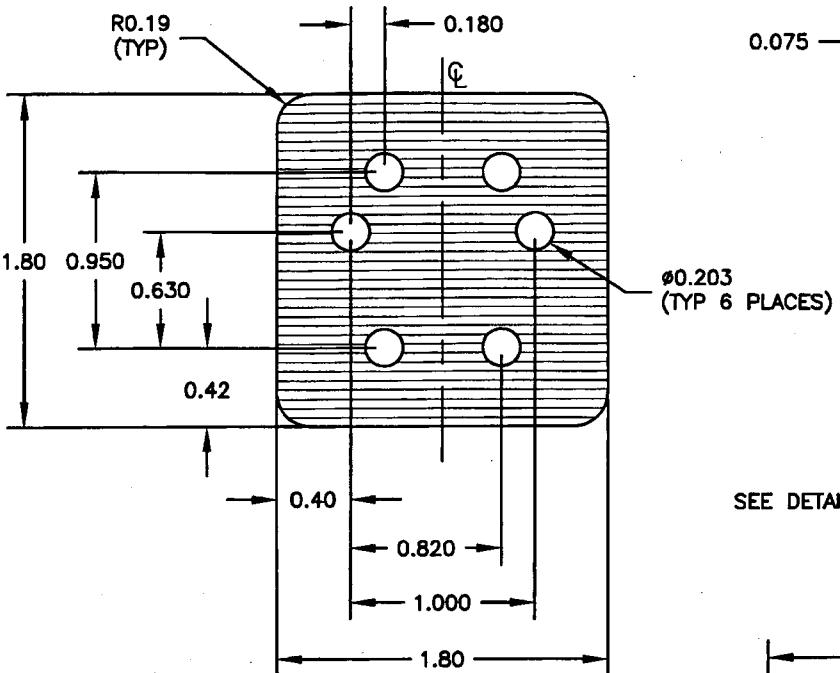
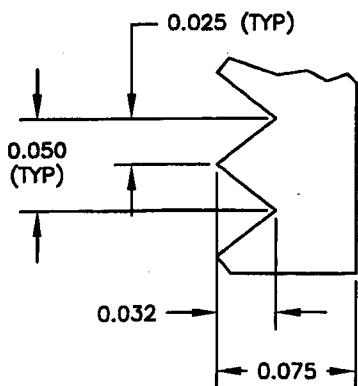
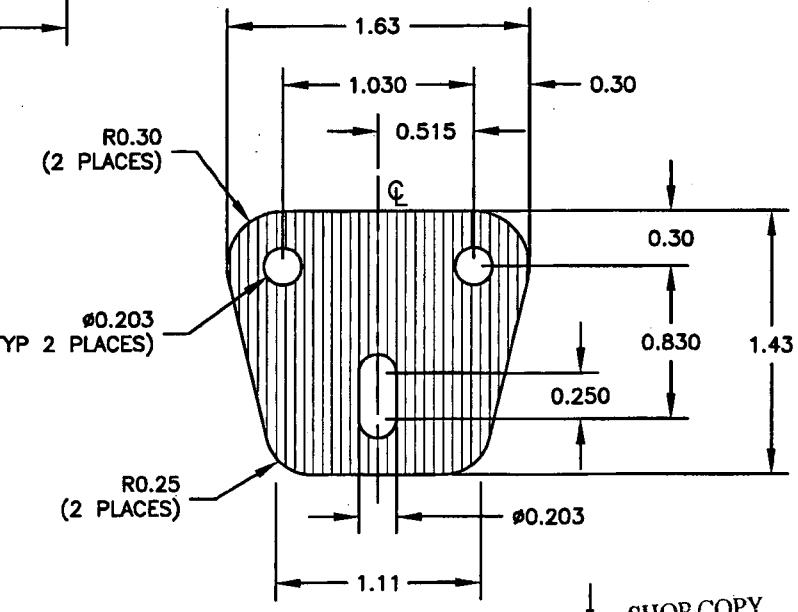
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

SEE DETAIL A SHOP COPY

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

DART

| | | |
|---------|----------|---|
| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA |
| CHECKED | APPROVED | DRAWING NO. D3238 |
| DATE | | REV. C SHEET 3 OF 3 SCALE 1:1 |

**RELEASED**07.02.20 *[Signature]***D3238-23 PLATE (SHOWN)**
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)**DETAIL A**
RIDGE DETAIL (VIEW MAY BE ROTATED)
SCALE 10:1**D3238-25 PLATE (SHOWN)**
D3238-35 PLATE (SAME, EXCEPT WORK ORDER
0.020 THICK AND NO SERRATIONS) *02224*
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